

Date: Friday, 14/11/2008 10:21:10 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PEDAL ASSEMBLY		
Job Number	: 43446			Part Number	: D3204041		
Estimate Number	: 10504			Drawing Number	: D3204 REV. A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/11/2008 S.O. No. :			Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 28/11/2008 Qty: 4 Um: Each		
Previous Run	: 38189						
Written By	:						
Checked & Approved By	: <u>JKL 08.11.14</u>						
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D32041	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Tube	
		Pick:	
		Qty Part Number Description Batch	
		1 D3204-1 Tube 1x38200 3X38321	<u>R 8-11-14 X4</u>
2.0	D32043	Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Arm	
		Pick:	
		Qty Part Number Description Batch	
		1 D3204-3 Arm <u>D43508</u>	<u>EL 8-11-24 X3</u>
3.0	D32045	Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Arm	
		Pick:	
		Qty Part Number Description Batch	
		1 D3204-5 Arm <u>B38201</u>	<u>EL 8-11-24 X3</u>
4.0	D32049	Pedal	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pedal	
		Pick:	
		Qty Part Number Description Batch	
		1 D3204-9 Pedal <u>B38208</u>	<u>EL 8-11-24 X3</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 14/11/2008 10:21:10 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43446

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D320411

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty Part Number Description Batch
1 D3204-11 Plate B35874

EL 8-11-24 X4

6.0 D320413

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

Batch: B35970

EL 8-11-24 X6

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
- 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
- 3- Use JB weld compound to plug the hole after assembly.
- 4- Grind JB weld flush after it is cured.

Identify as D3204-041

EL 8-11-24

EL 8-12-1

8.0 QC9

VISUAL WELDING INSPECTION



(x3)

Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



③

Comment: INSPECT WORK TO CURRENT STEP

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(3X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/12/01

11.0 POWDER COATING

POWDER COATING



(3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

START TIME:

9:00

M-1 08/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 14/11/2008 10:21:10 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43446

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

01

Description :

(3X)

OVEN TEMPERATURE: 320

FINISH TIME: 9:30

M-1 08/12/02

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11



Comment: INSPECT POWDER COAT

08-12-02

(3X)

13.0 D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D3204-7	Bushing	<u>524722</u>

B 35632

E 08/12/02

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/03

(43)

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST200

A S 08/12/03(3)

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/03 A

Job Completion



MF 08-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

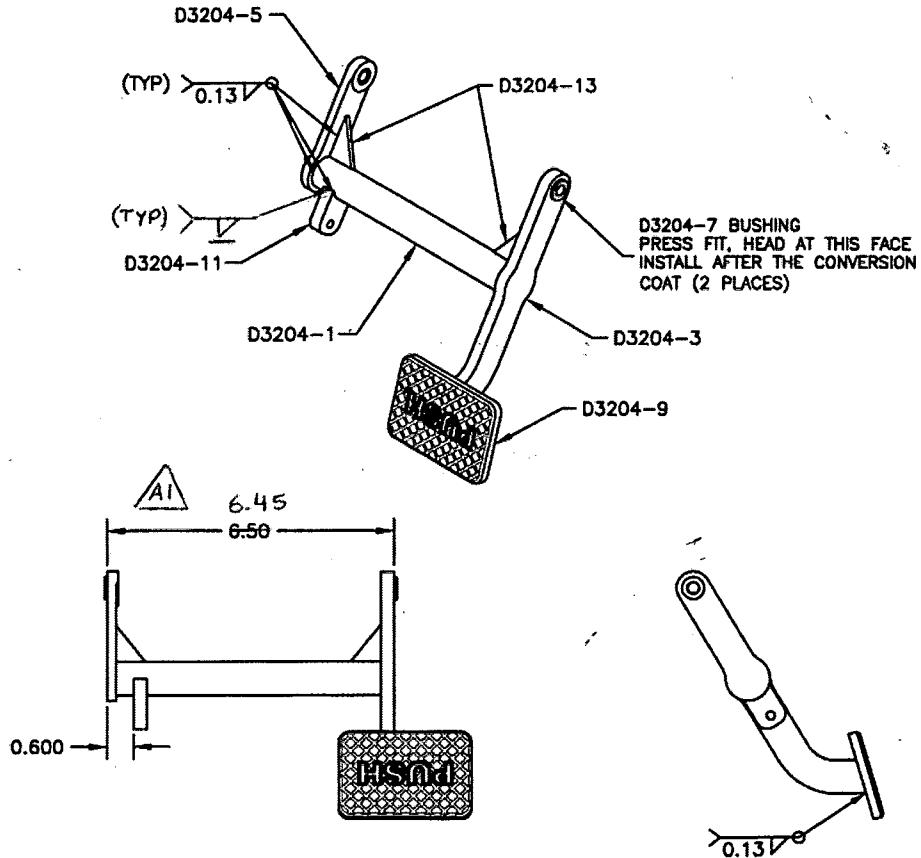
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

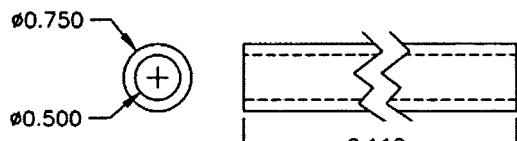
RELEASED
04.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

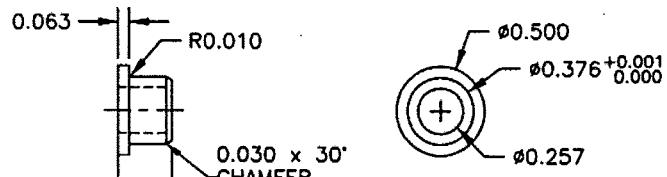
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DART

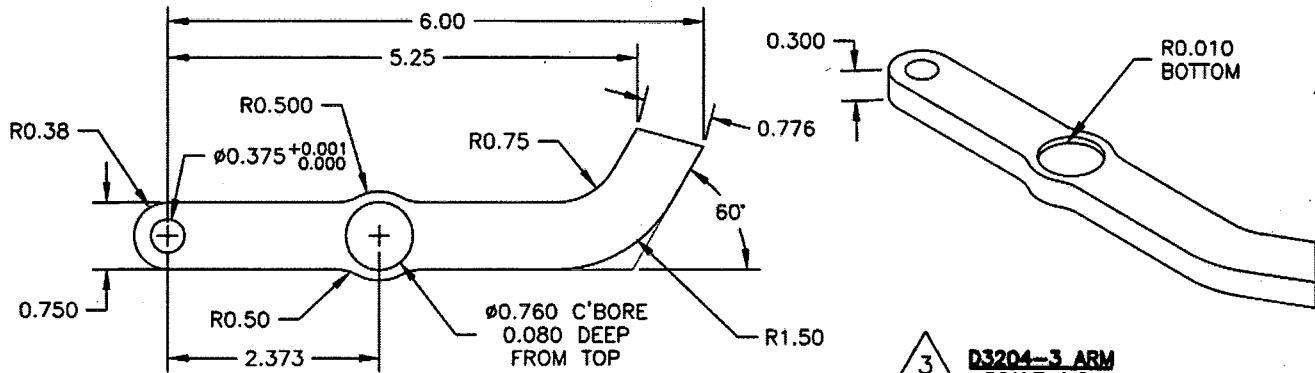
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	

RELEASED
04.04.05 #

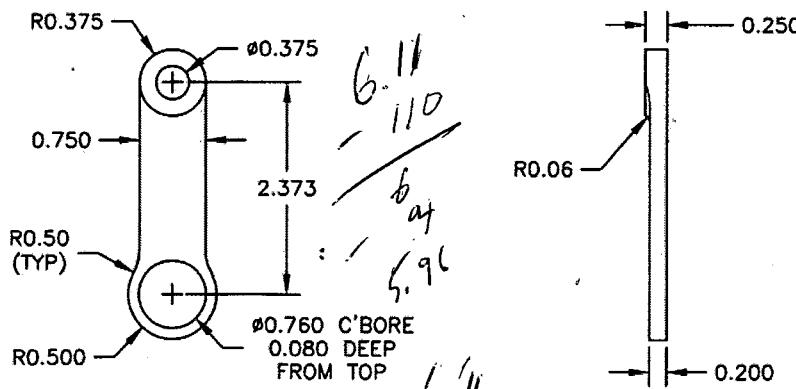
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

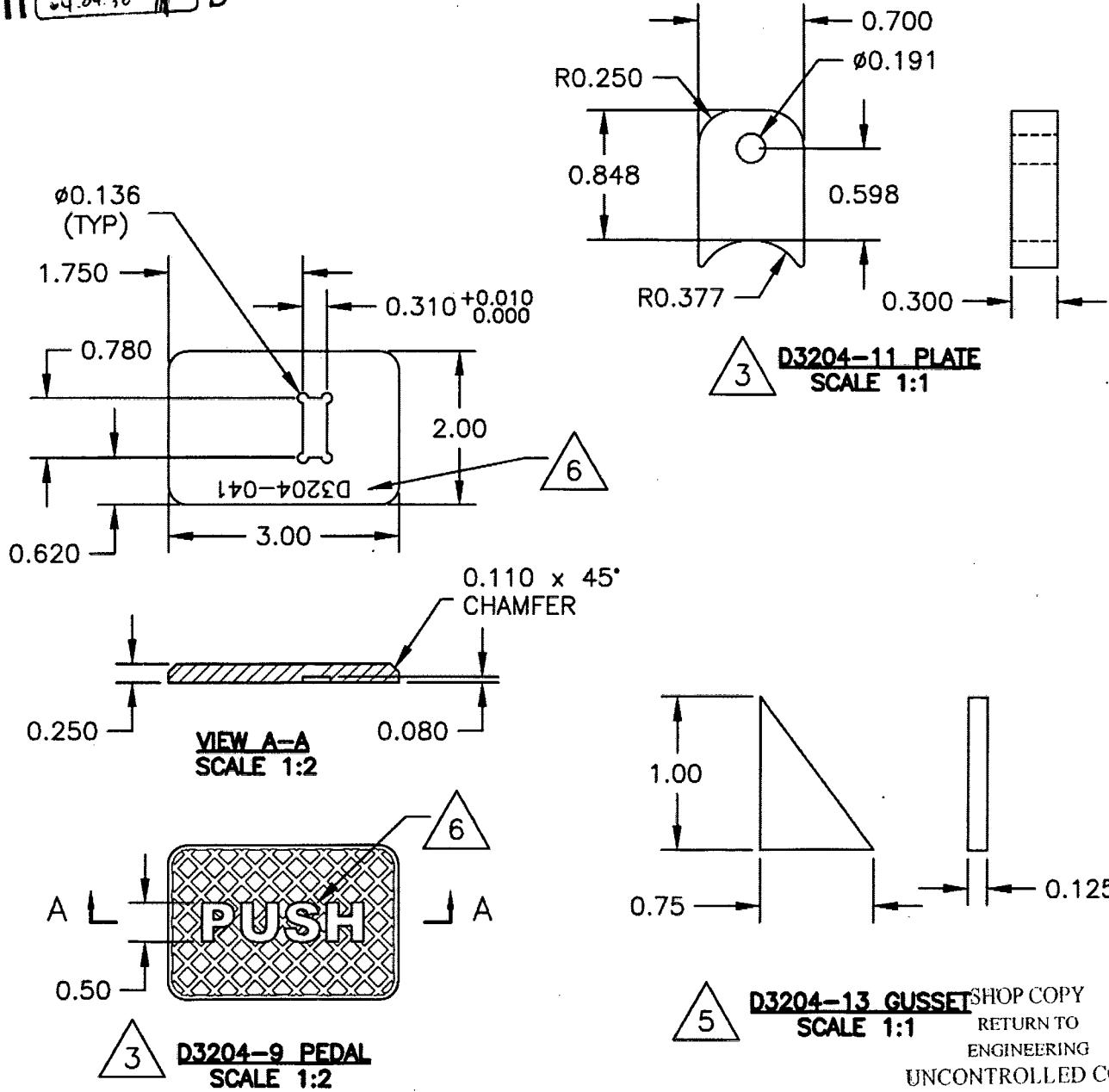
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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	

RELEASED
04.04.70

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